

Work Order ID 96006

January 17-13 1:19:39 PM

96006

Page 1

Item ID: D3805-045

Revision ID:

Item Name: Wearplate Assembly Aff. Low Gear

Start Date: 1/17/13

Start Qty: 8.00

Required Date: 1/31/13

Req'd Qty: 8.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 13-01-17 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3805

B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- On D3806-5, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: m127112 → 20596

2-weld D3806-5 to D3805-5 together as per dwg D3805

304 S.S. Welding Rod

BATCH#: m126048

3-Transfer drill holes in bar

CUT BAR TO FINISH SIZE AFTER WELDING HARD COAT

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

Ⓢ cc/2R 13-11-25

Ⓢ 13-11-25 DAS 09

Work Order ID 96006

January 17-13 1:19:39 PM

96006

Page 2

Item ID: D3805-045

Revision ID:

Item Name: Wearplate Assembly Alt. Low Gear

Start Date: 1/17/13 Start Qty: 8.00

Required Date: 1/31/13 Req'd Qty: 8.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

120

QC5- Inspect part completeness to step on W/C

0.00

120

QC

Memo

0.00

Quality Control

② 13.11.25

DAS
09
2-89

130

Grey Sandtex(Ref:4.3,5,6) per QSI005 4.3

0.00

130

Powdercoat

M125078

Memo

0.00

Powder Coating

START TIME: 1:40
OVEN TEMPERATURE: 320°
FINISH TIME: 2:10

2 @ 13.11.27.

DAS
34
9-89

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

13.11.27

②

DAS
27
9-89



Work Order ID 96006

January 17-13 1:19:39 PM

96006

Page 3

Item ID: D3805-015
 Revision ID:
 Item Name: Wearplate Assembly All Low Gear
 Start Date: 1/17/13 Start Qty: 8.00
 Required Date: 1/31/13 Req'd Qty: 8.00
 Reference:

Accept

N9000040100

Setup Start *NS1*
 Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:
 QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start *NR1*
 Stop *NR2*

Sequence ID/
 Work Center ID

Operation
 Description

Set Up/
 Run Hours

Tool ID

Tool #

Plan
 Code

Accept
 Qty

Reject
 Qty

Reject
 Number

Insp.
 Stamp

150

150

Small Fab

Small Fab

Apply rodguard per ASTM 005

Memo

0.00

1- Bond 123807-5 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg
 BATCH: *N/A*

B#125335

2

0

0

AS

13-11-27

160

160

QC

Quality Control

QC5- Inspect part completeness to spec on W/O

0.00

Memo

0.00

2

DAS 05

13-11-28

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: *EP-001*

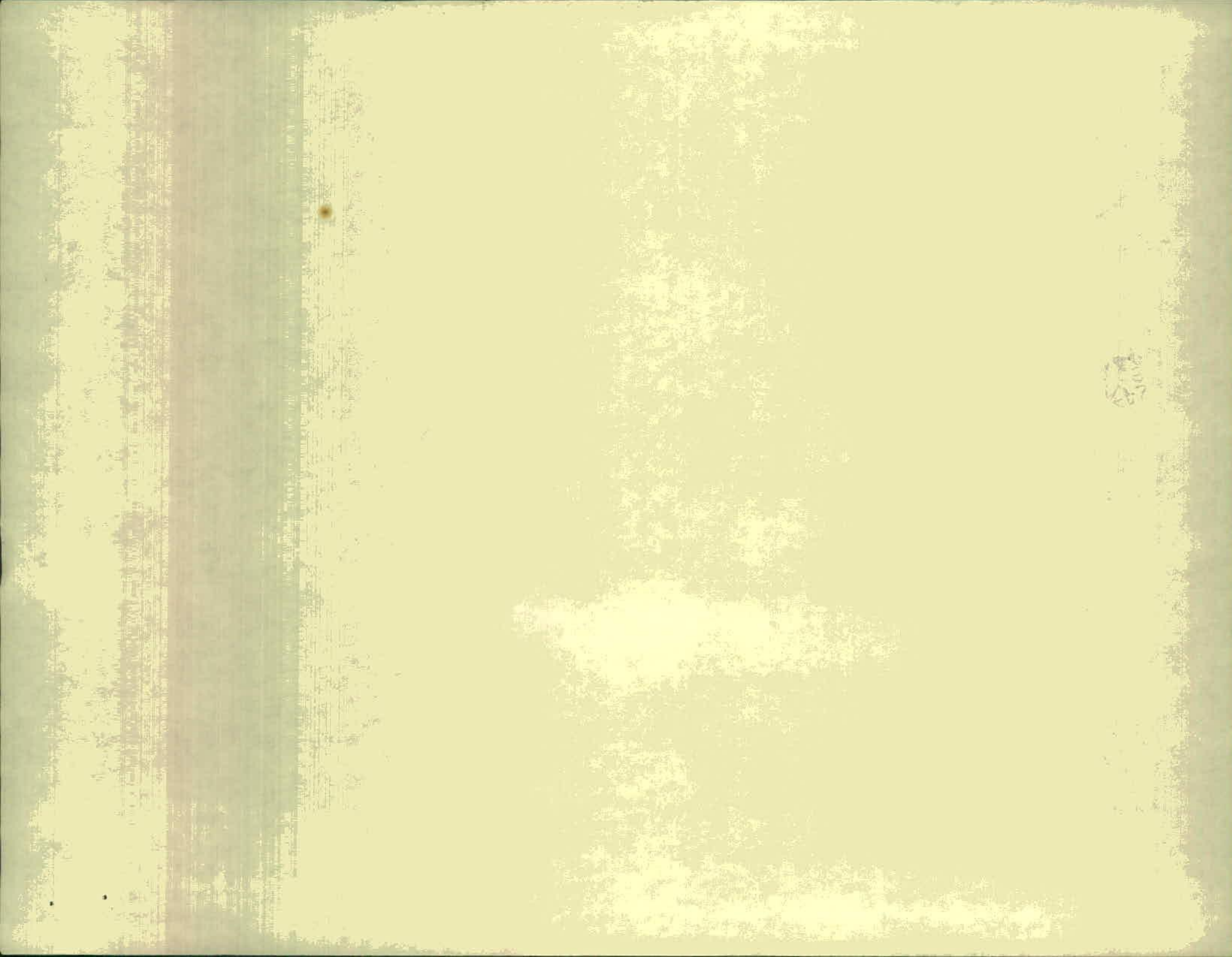
0.00

Memo

0.00

x2

6 Muz 11/26



Work Order ID 96006

January-17-13 1:19:39 PM

96006

Page 4

Item ID: D3805-045

Revision ID:

Item Name: Wearplate Assembly Aff. Low Gear

Start Date: 1/17/13 Start Qty: 8.00

Required Date: 1/31/13 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

180

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

180

QC

Memo

0.00

Quality Control

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

[Signature] RM 13/11/28

ME 13-11-28

Picklist Print

January 17-13 1:19:43 PM

Page 1 1/2

Work Order ID: 96006

96006

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aff. Low Gear

Start Date: 1/17/13

Required Date: 1/31/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-5		Manufactured	No			100	Each	22,0000	1	82			
D3805-5									**	(x2)		me	13.11.25
Plate													

B 96008 x 2

Location	Loc Qty	Loc Code
WA001	22	
75676	2	
91208	8	
91211	4	
93679	6	
93680	2	

D3806-5

Manufactured No

100 Each 22,0000 1 82

D3806-5

Bar

**

CC 13-4-17

Location	Loc Qty	Loc Code
WA001	22	
46781	2	
75941	2	
91212	12	
93682	6	

B 96010

(x2)

Picklist Print

January-17-13 1:19:43 PM

Page 2

Work Order ID: 96006

Parent Item: D3805-045

Parent Item Name: Wearplate Assembly Aft. Low Gear

96006

D3805-045

Start Date: 1/17/13

Required Date: 1/31/13

Start Qty: 8.00

Required Qty: 8.00

D3807-5

Manufactured

No

150

Each

112.0000

1

8

D3807-5

Gasket

**

Location

Loc Qty

Loc Code

GA

112

74944

1

78132

3

79572

2

90485

1

91214

79

92779

1

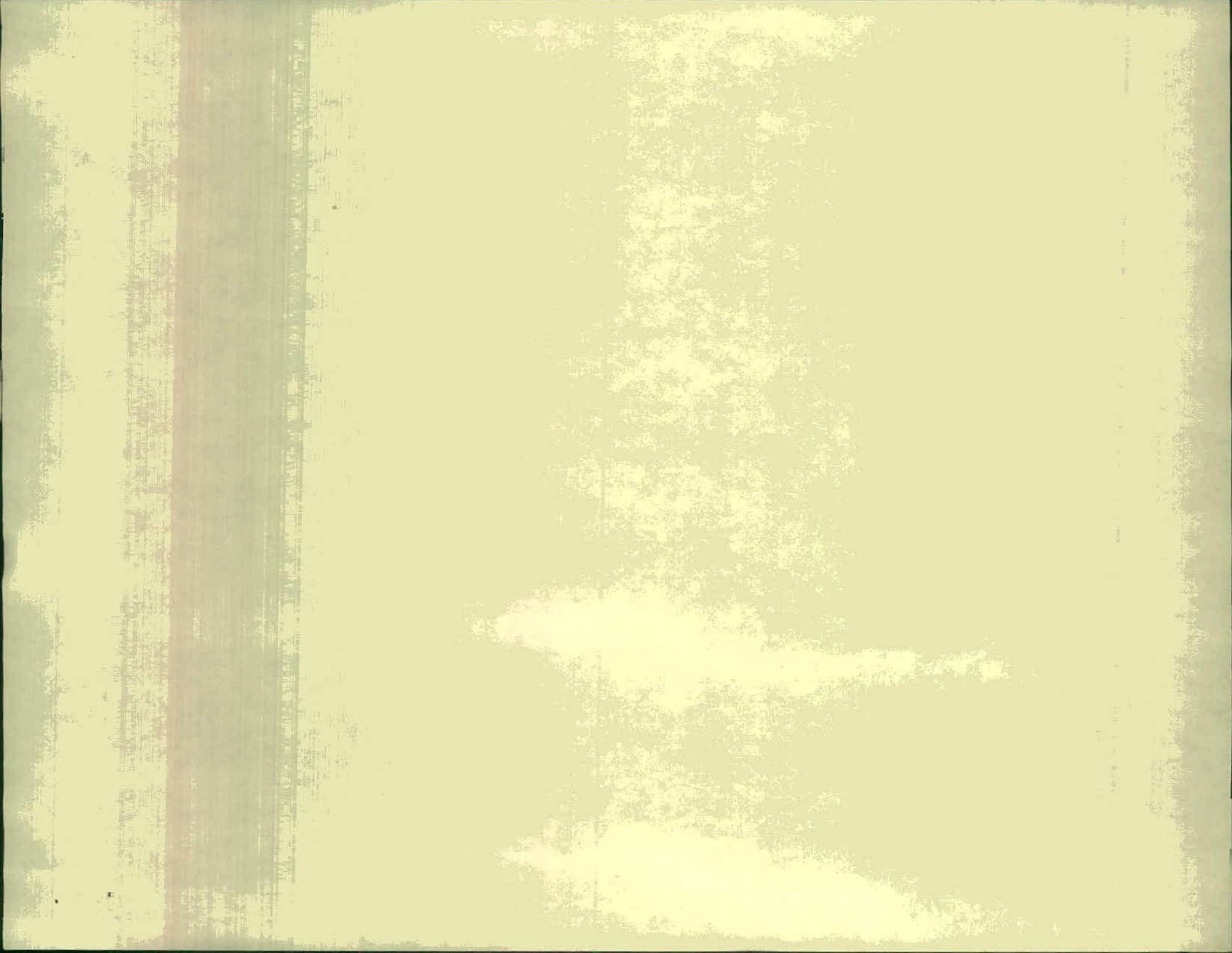
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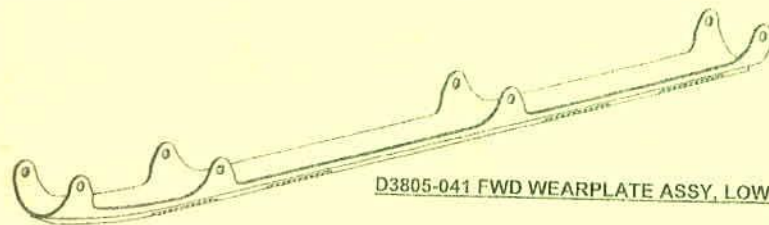
25

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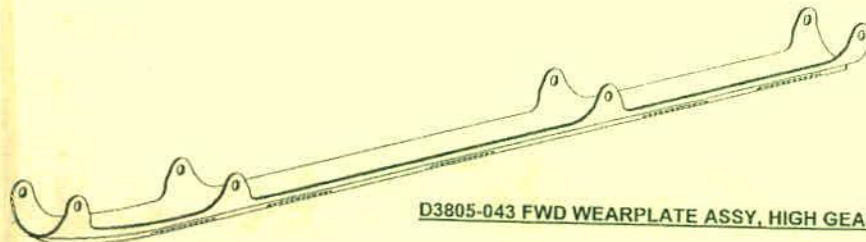
Shop Packet Print

Page 2

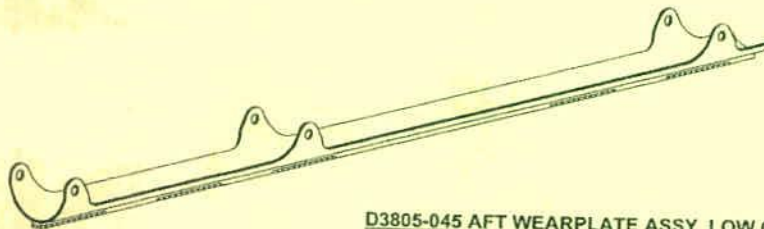




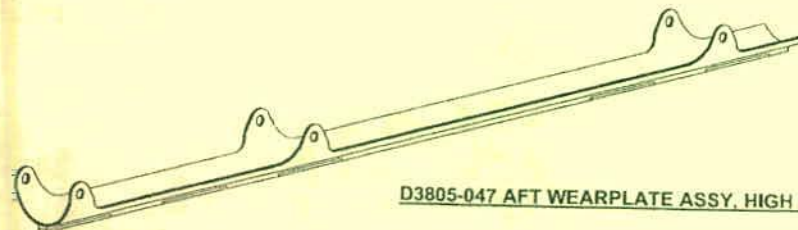
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

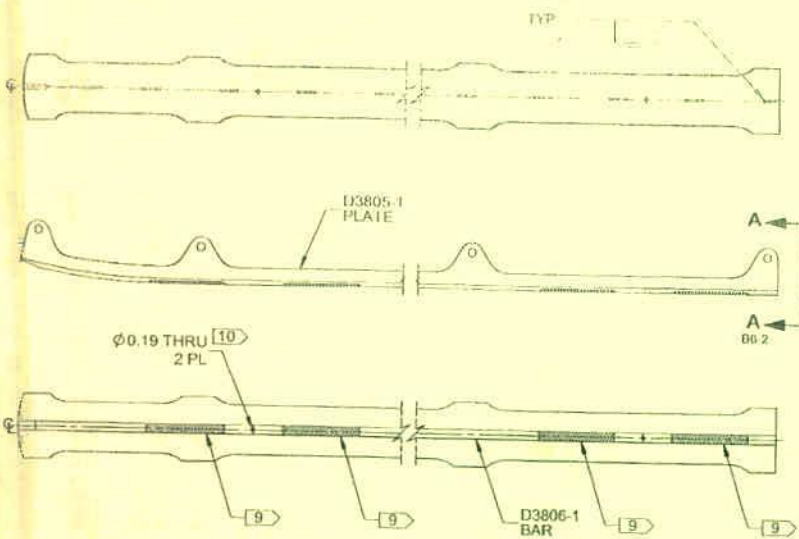
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

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2011-10-03

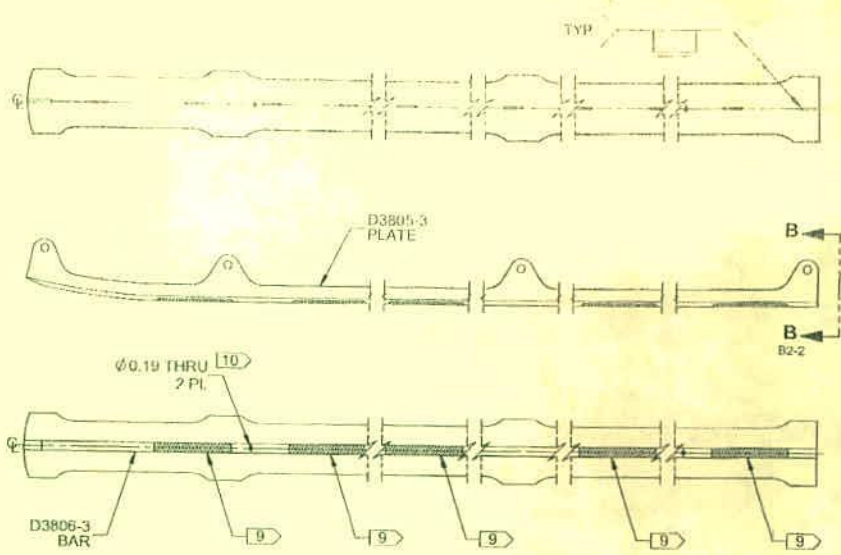
96006 MLJ
13-01-17

B	REVISED D3805-1F1-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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96006



D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2

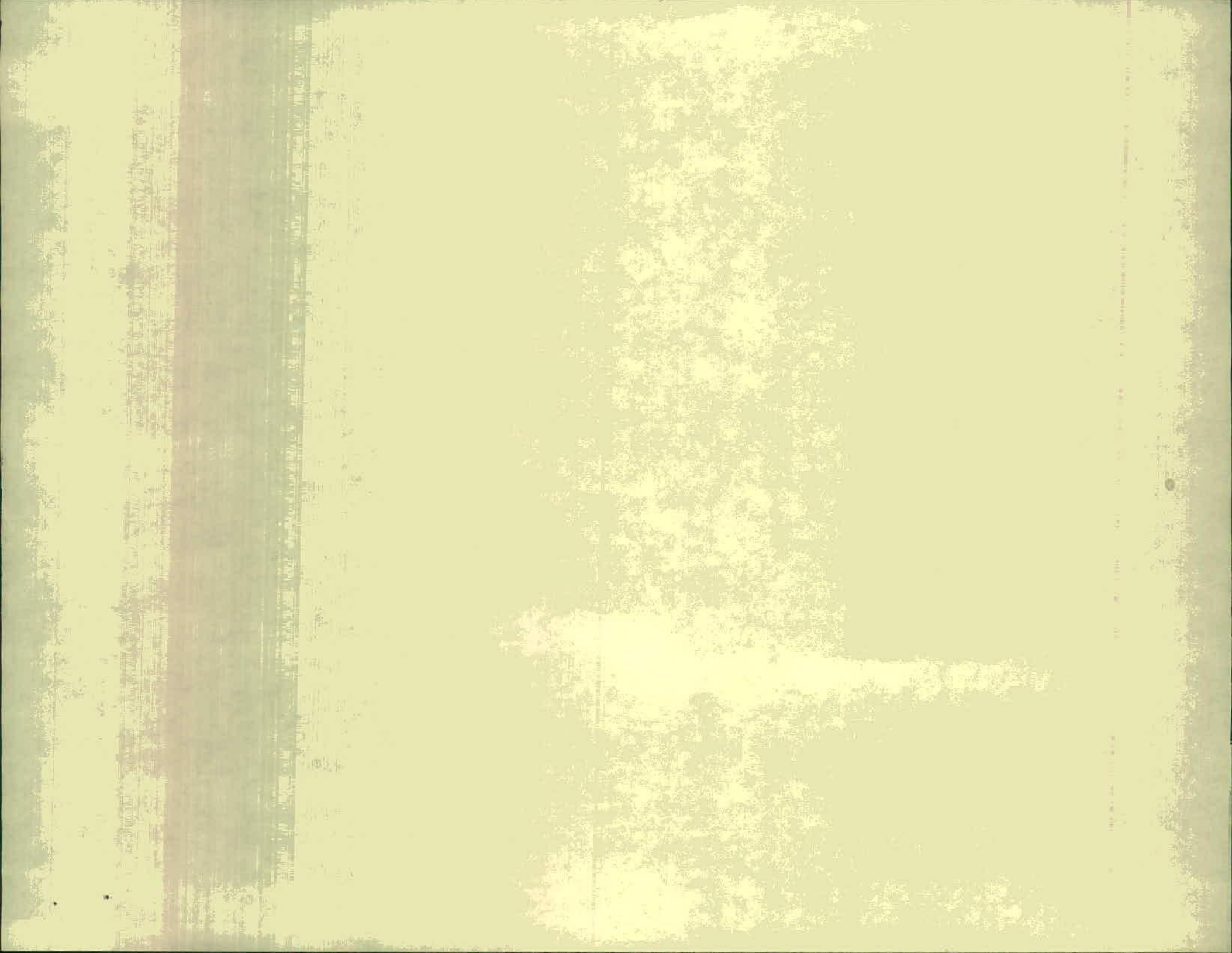


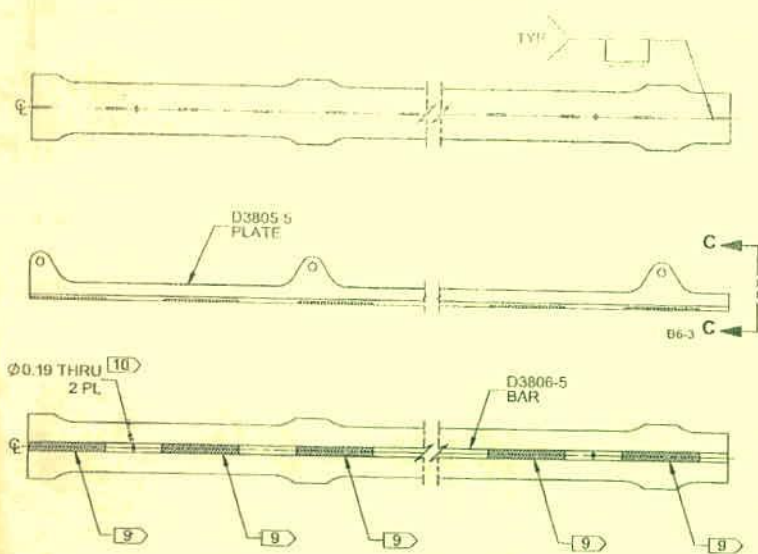
VIEW B-B C1-2

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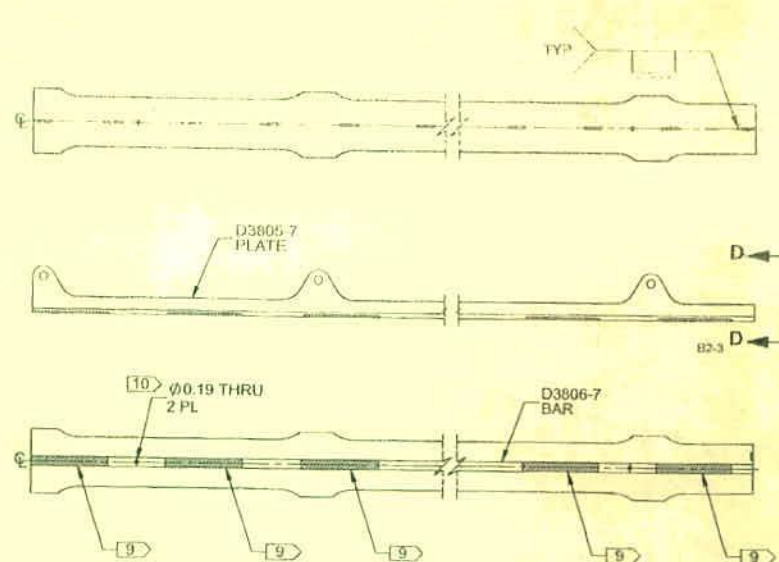
- NOTE:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
 - 8) WELDING: PER QSI 004
 - 9) 205GB HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
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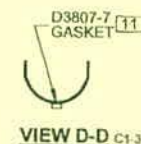
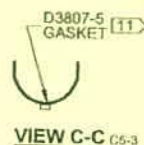




D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



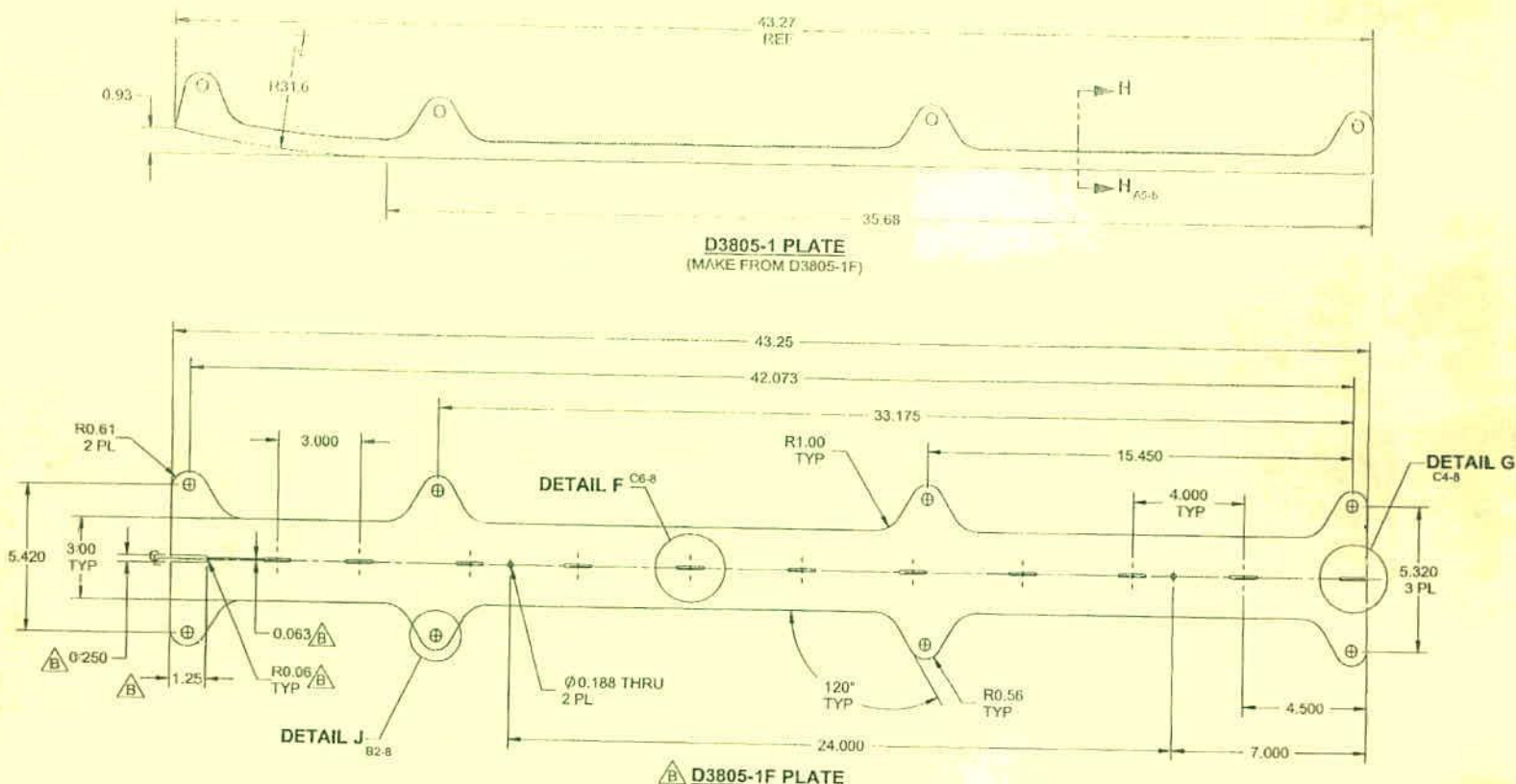
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2011-10-03
JMP

NOTE:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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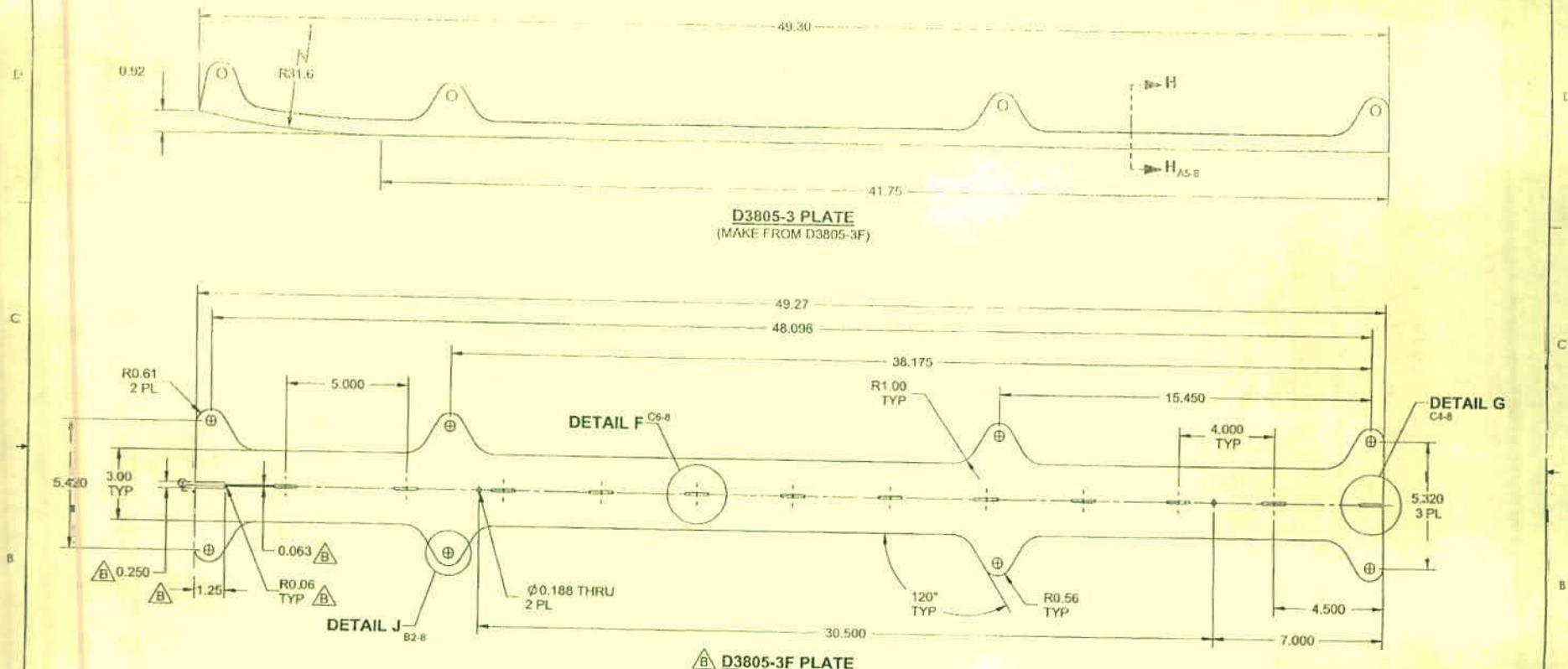


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2011-10-03

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

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MFG. APPR.		D3805	SHEET 4 OF 6
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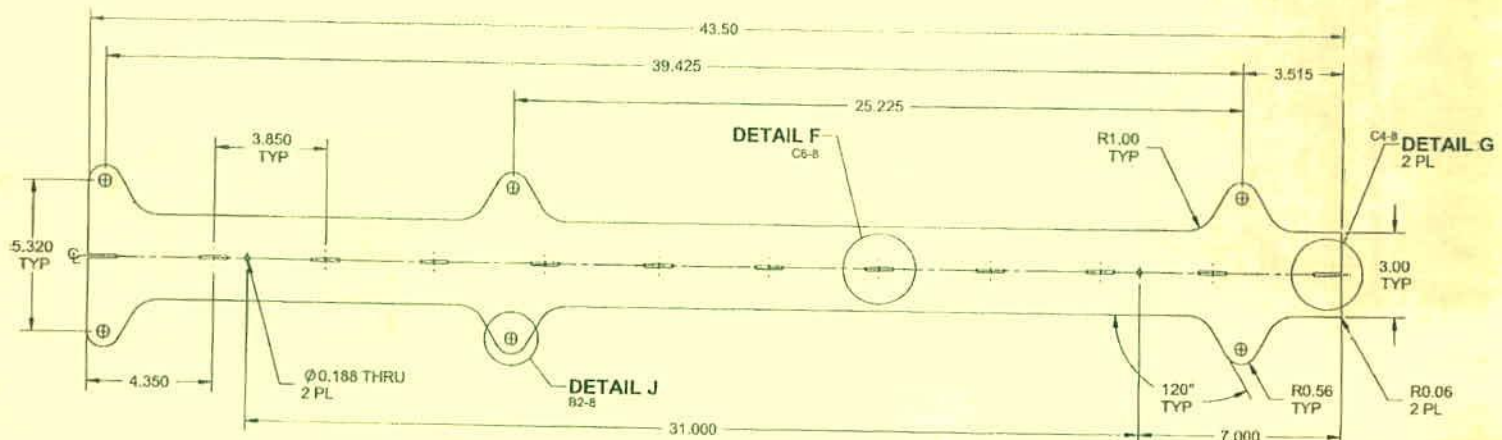
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- NOTES:
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.36 lbs

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D3805	SHEET 5 OF 8
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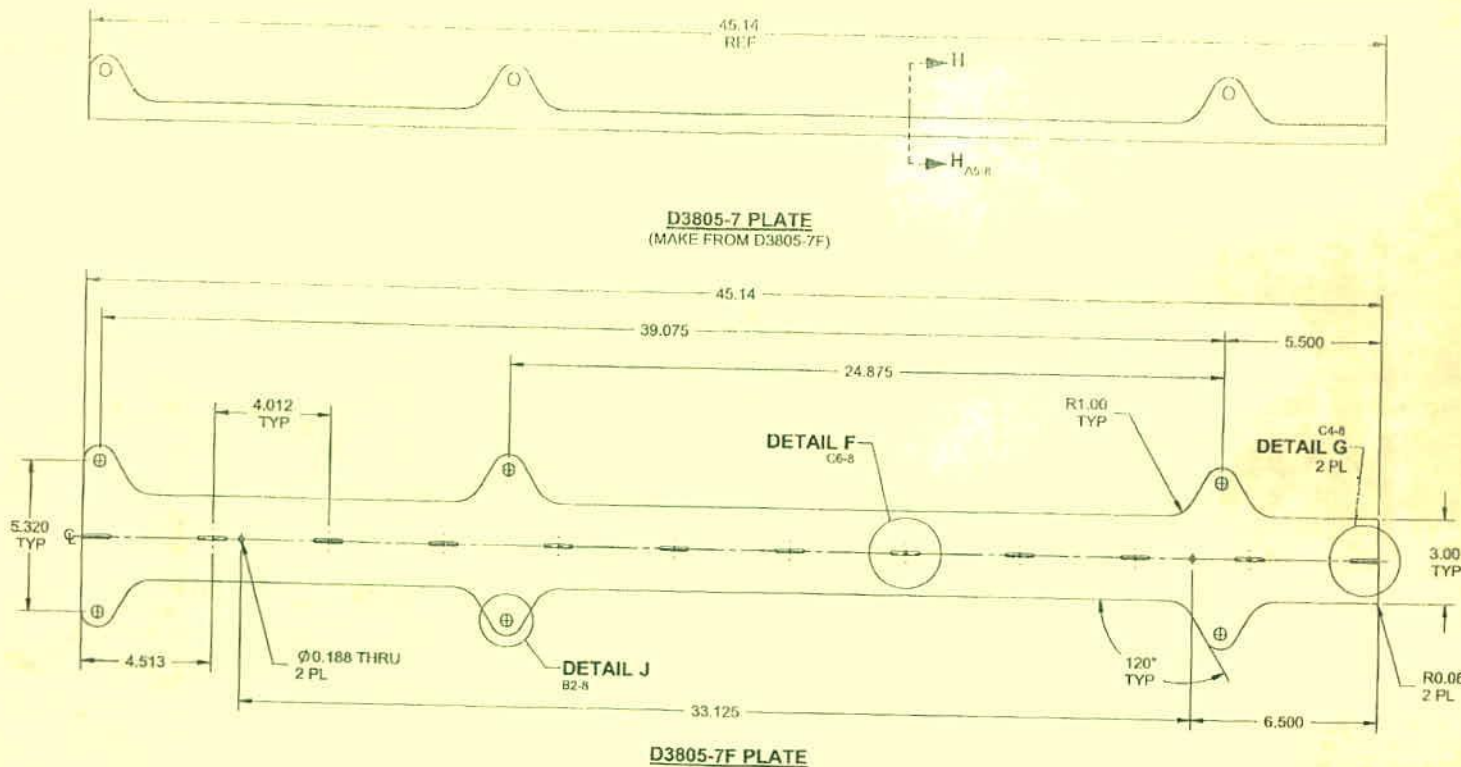


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- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK: SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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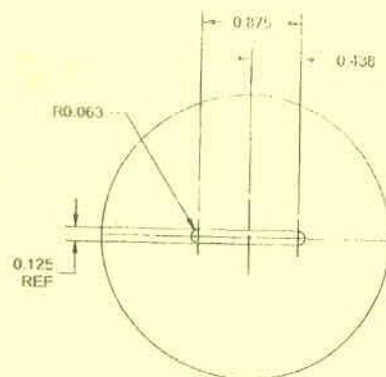
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2011-10-03

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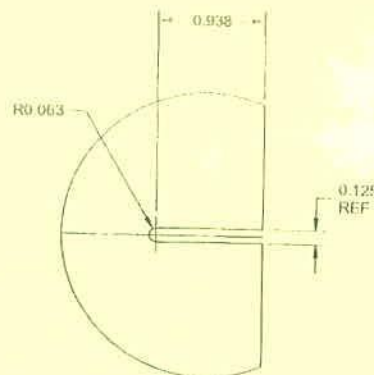
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

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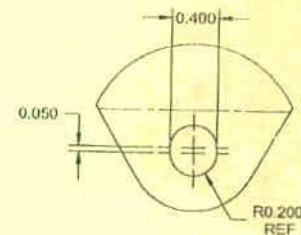
94006



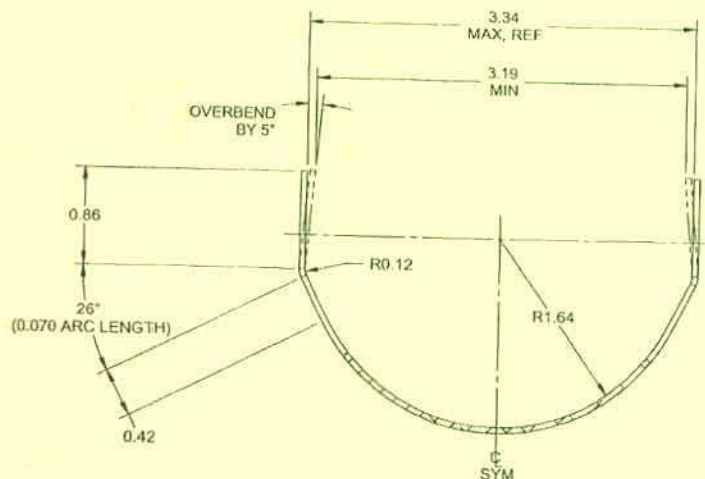
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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2011-10-03

DESIGN		DART AEROSPACE USA, INC.
DRAWN	<i>[Signature]</i>	KENT, WA
CHECKED	<i>[Signature]</i>	DRAWING NO. D3805
MFG. APPR.	<i>[Signature]</i>	REV. B
APPROVED	<i>[Signature]</i>	SHEET 8 OF 8
DE APPR.	<i>[Signature]</i>	TITLE WEARPLATE ASSY
DATE	11.09.16	SCALE NTS

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